

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029720**Date Inspected:** 12-Jun-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** USA Hoist**Location:** Crest Hill, IL

<b>CWI Name:</b>	Robert Zimny		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	SAS Tower Elevator	

**Bridge No:** 34-0006**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at USA Hoist, Crest Hill, IL as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

Today at the USA Hoist fabrication shop, this QA randomly observed USA Hoist Quality Control (QC) Inspector Robert Zimny perform visual inspection on completely fillet welded 142 pieces of rear tie-in bracket. These brackets were previously welded per USA Hoist shop drawing #914204-11. During the QC inspection, MR. Robert Zimny was noted performing visual inspection on the ¼" fillet weld on all sides of the 4 ½" long x 3" wide x 3/8" thick stiffener plate to the rear tie-in bracket as well as measuring the required fillet size. The QC inspection was completed with one bracket rejected due to bad surface profile of the weld. This rejected one bracket will be put aside and will be fixed later per USA Hoist due to this was considered extra. USA Hoist anticipates only using 122 pieces out of the 142 pieces that were made.

After the completion of the QC inspection on all 142 pieces of the rear tie-in brackets, this QA also performed visual verification on the surface profile of the fillet welds. Except the one that was rejected by QC, this QA also randomly measured the size of the fillet that was welded on the brackets. Overall, after verifying the surface profile and the size of the fillet welds, this QA found the welds in compliance to the requirements of the project.

Since the 146 pieces front tie-in and 142 pieces tower tie-in brackets that were sent back to the bender shop have not returned yet, there was no welding work performed today and yesterday. USA Hoist is hoping that there will be partial returns on the corrected bend of the brackets tomorrow.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### Summary of Conversations:

No significant conversation occurred today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lizardo, Joselito
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Foerder, Mike
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QA Reviewer
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